

Date: Tuesday, 4/25/2006 7:36:00 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 26805		
Estimate Number	: 12396	Part Number	: D33537
P.O. Number	: N/A	Drawing Number	: D3353 REV.A
This Issue	: 4/25/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: N/A	Due Date	: 5/31/2006
Written By	: <u>SEE COMMENT BELOW</u>	Qty:	16 Um: Each
Checked & Approved By	: <u>9406.04.25</u>		
Comment	: est rev. A 06.04.24 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0375X03500	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.3360 f(s)/Unit Total : 1.3440 f(s)
 1010-1025 BAR .375" thick x 3.50" batch: M16634

M 06 05 02 10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3353
 Dwg Rev: A
 Prog Rev: A

M 06 05 03

16

2-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- Bore hole as per dwg D3353

2-Deburr

M 06/05/11

16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06/05/11

16

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

M 06/05/25

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 06/05/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:36:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 26805

Part Number: D33537

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SP428

sl 06/05/25 16

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/05/26 (16)

Job Completion



u 06/05/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

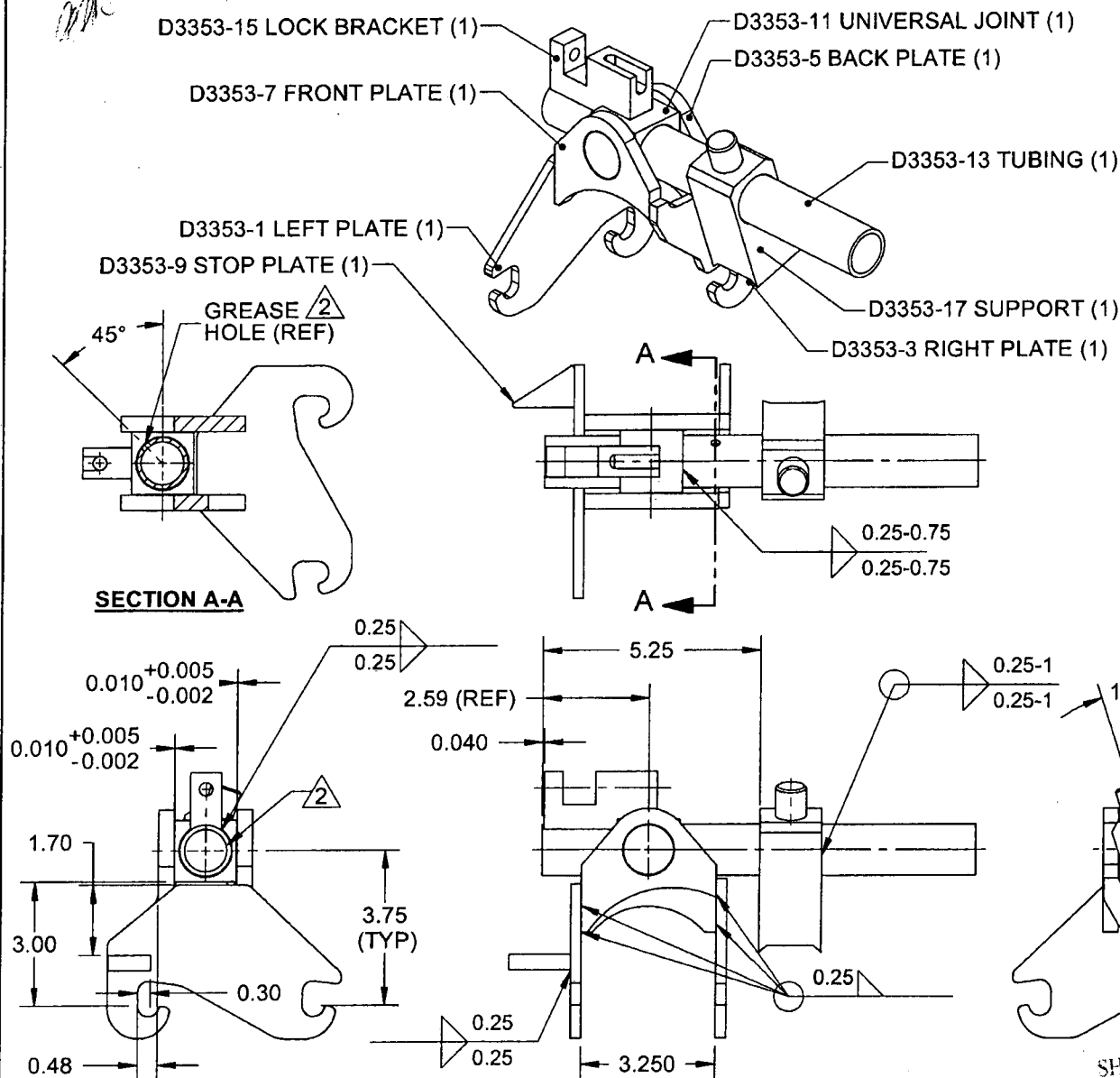
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
[Handwritten: 25/5/09]**D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

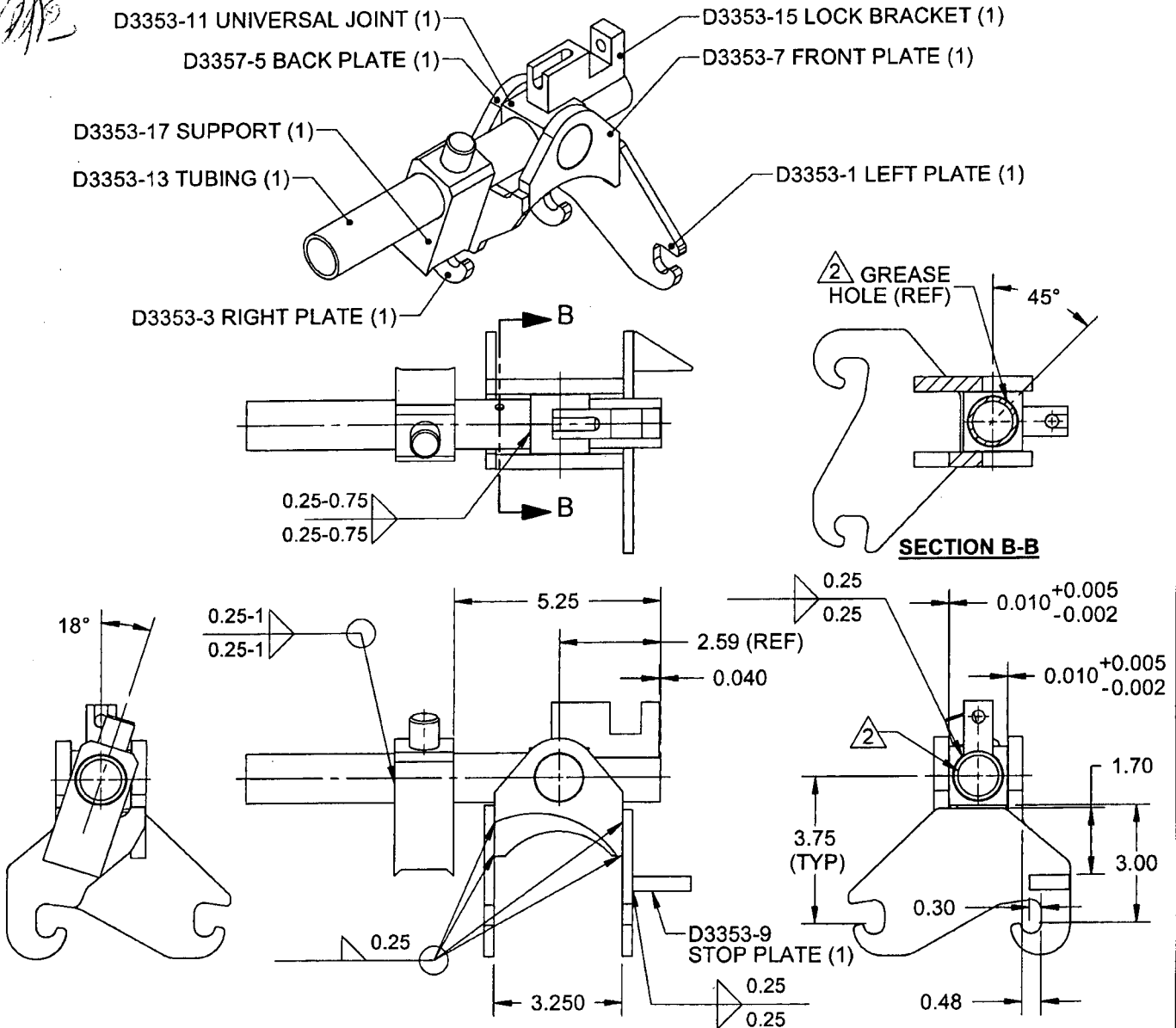
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4

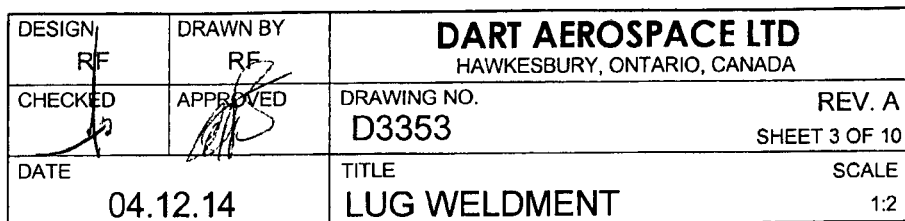
**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

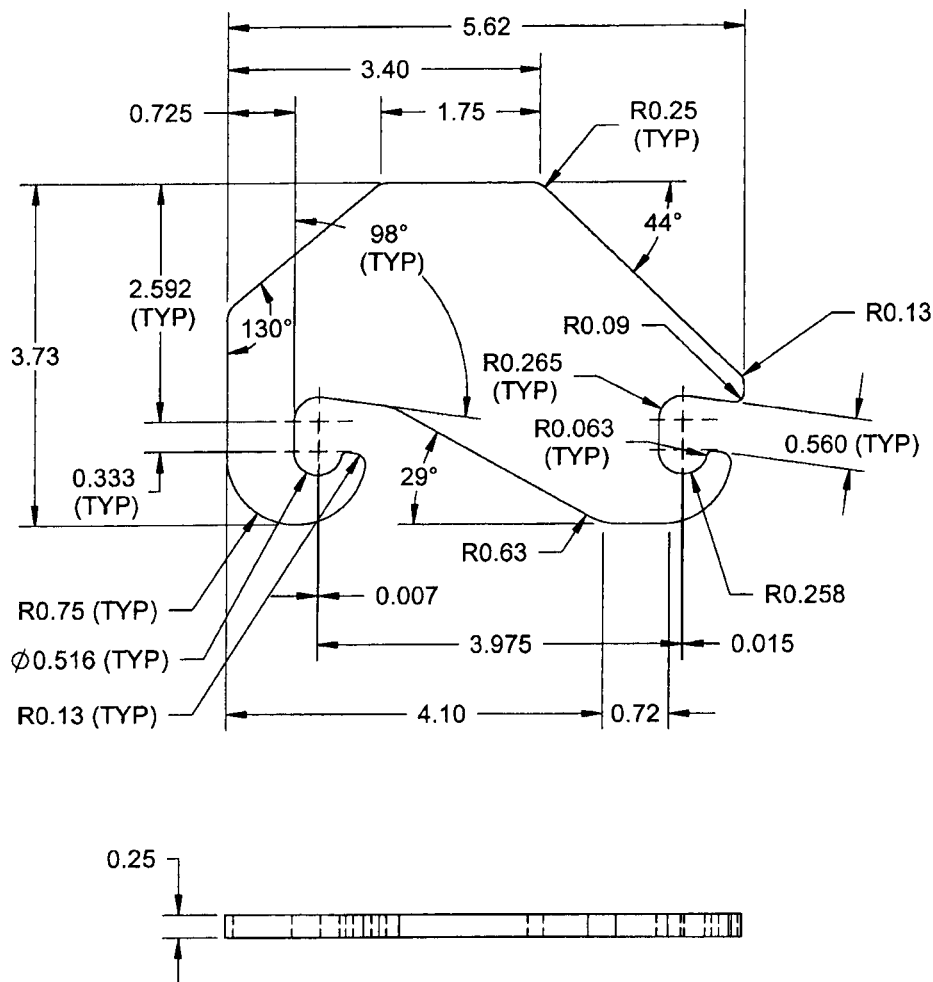
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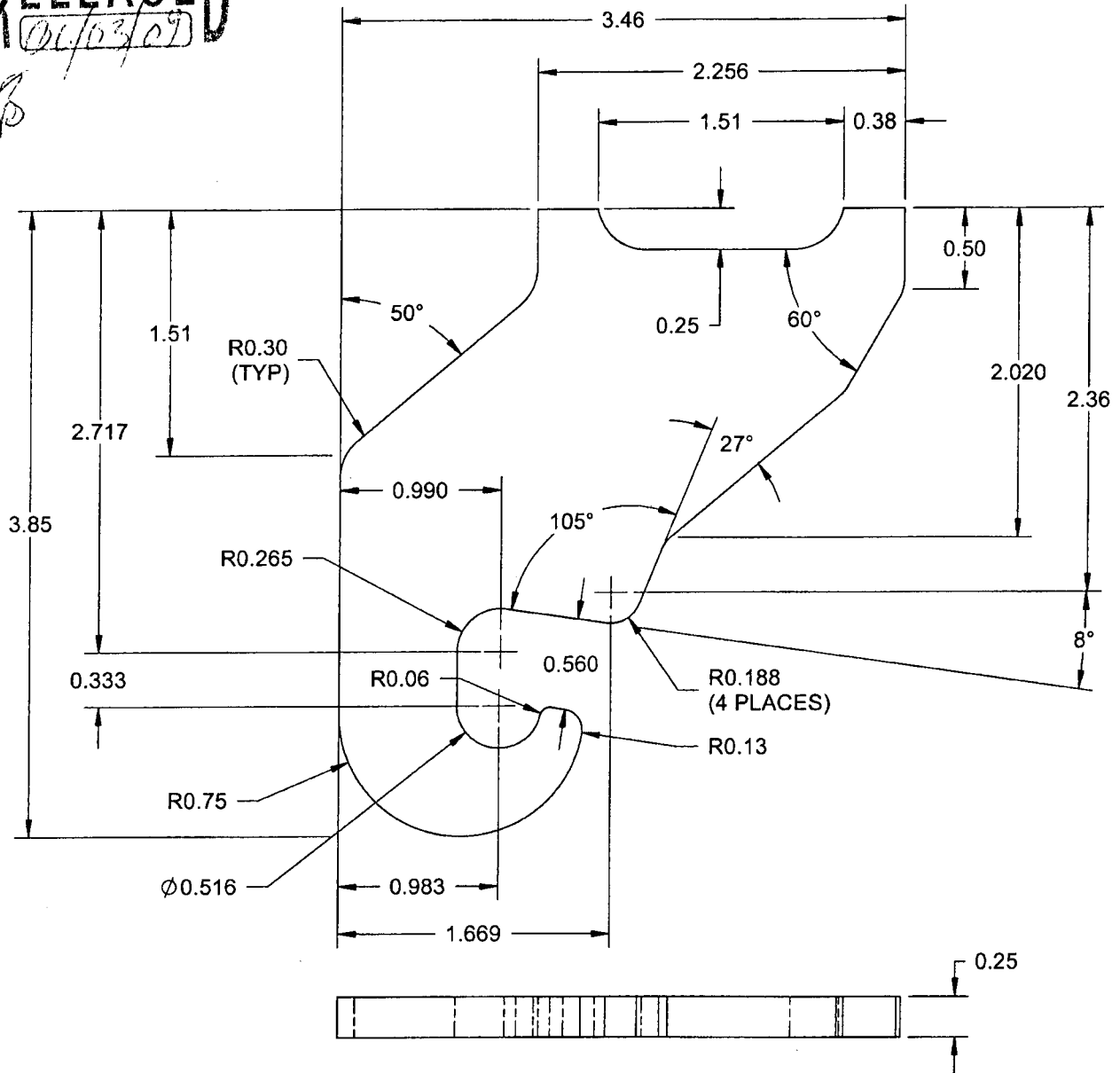
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, UNCONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK) SUBJECT TO AMENDMENT
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020 WORK ORDER

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
01/03/07**D3353-3 RIGHT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

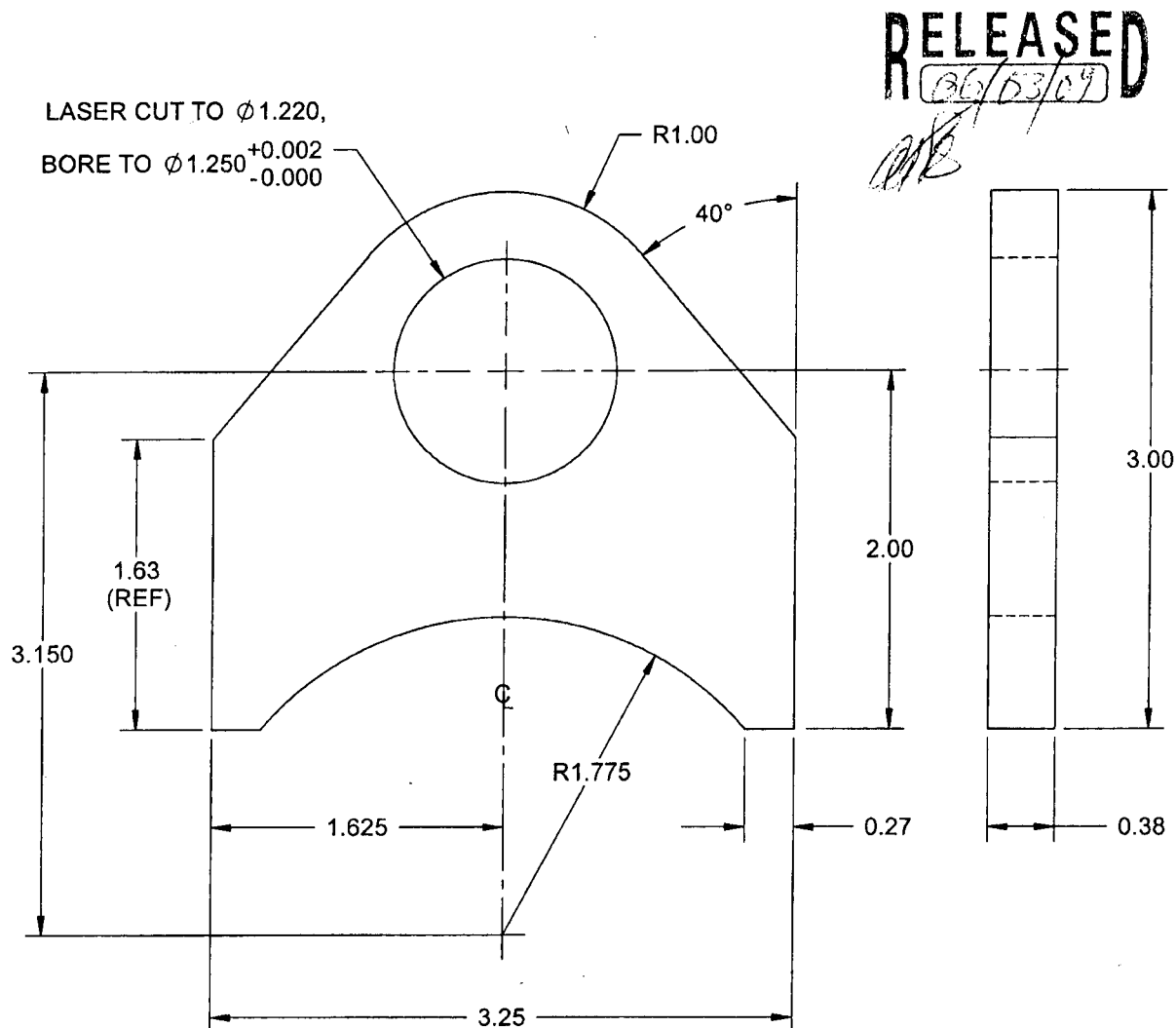
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 5 OF 10 SCALE 1:1

**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

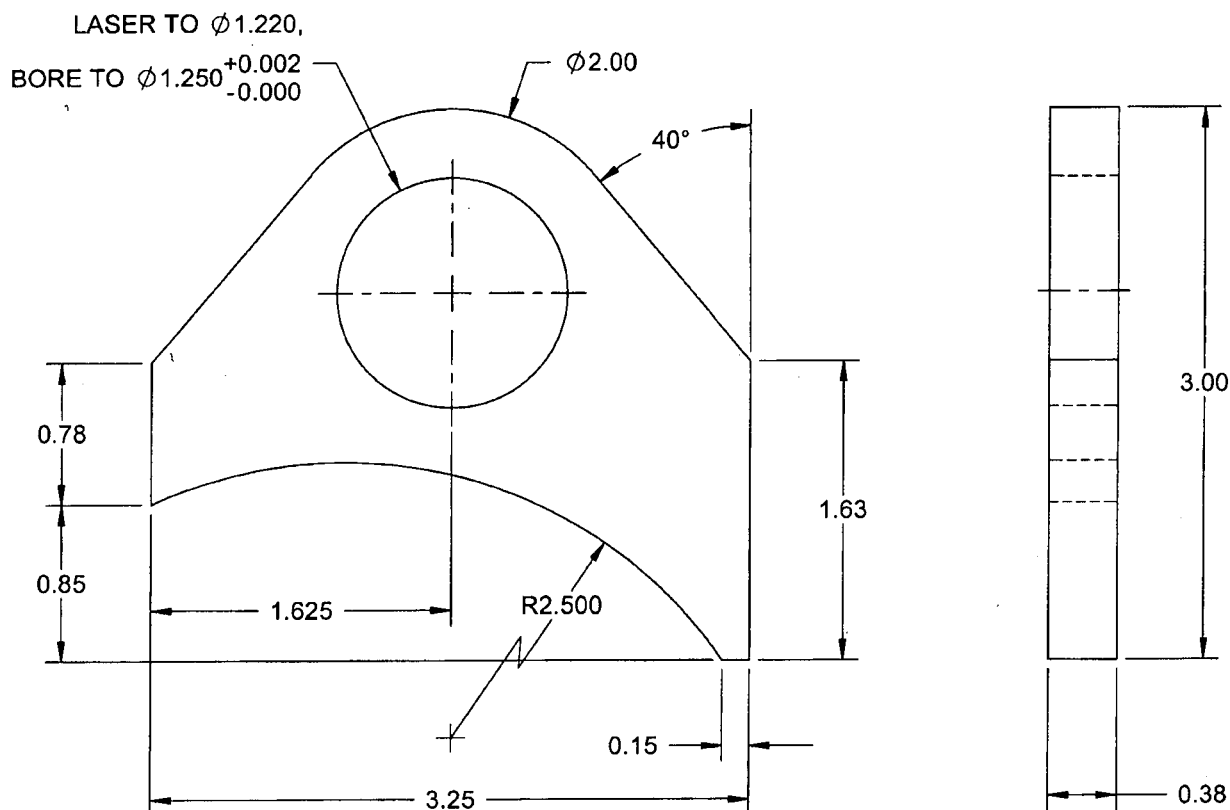
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1

RELEASED
06/03/07**D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

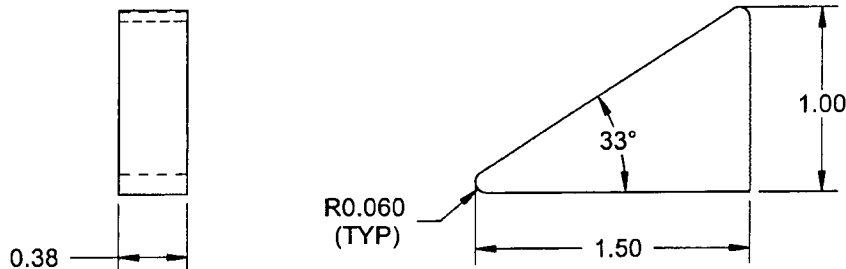
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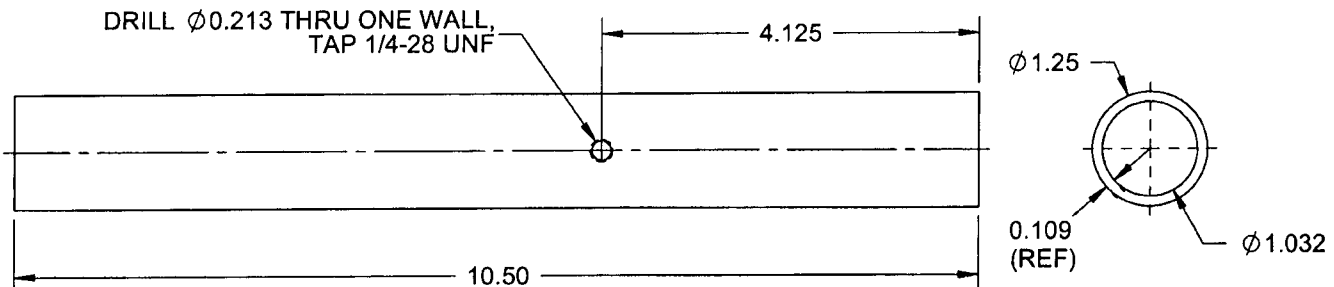
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
32/33/04*[Signature]***D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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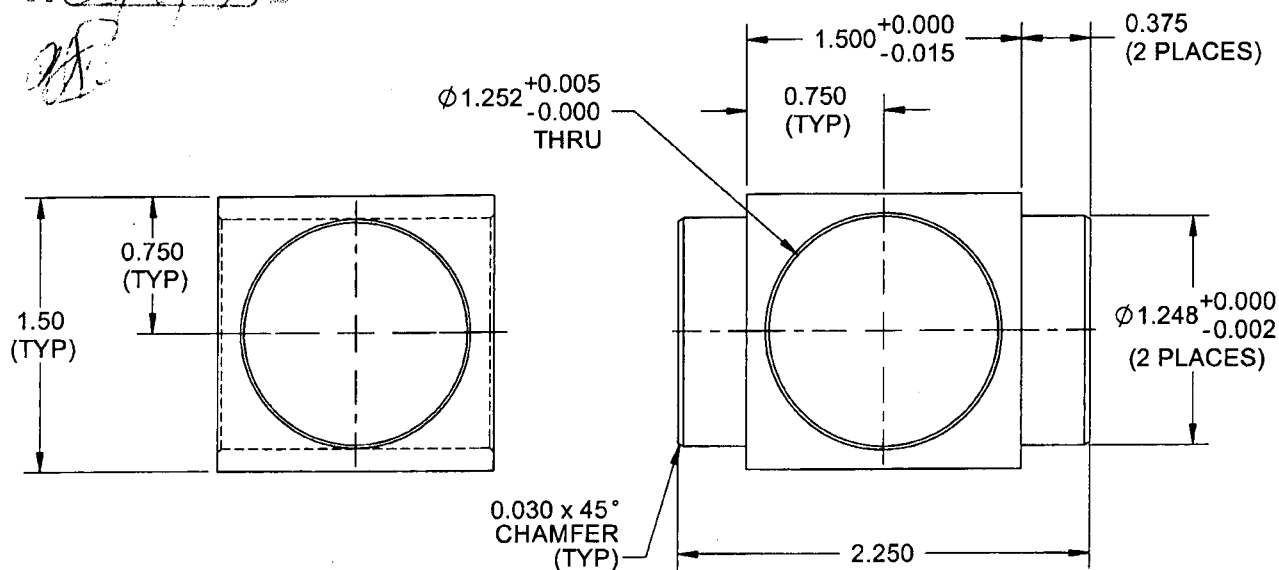
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/33/09



D3353-11 UNIVERSAL JOINT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

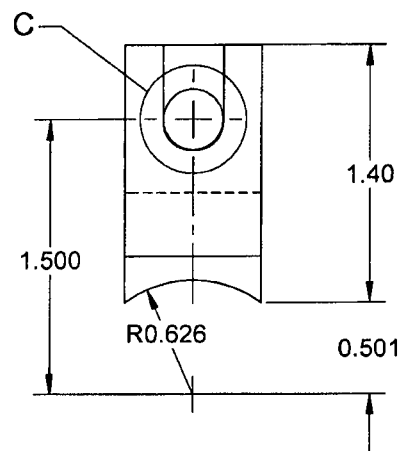
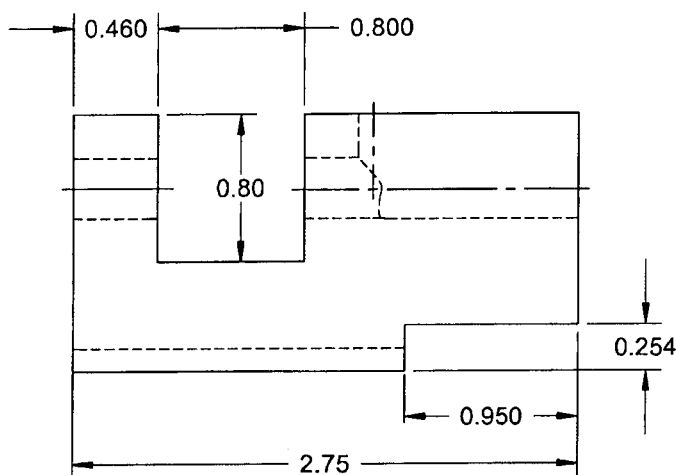
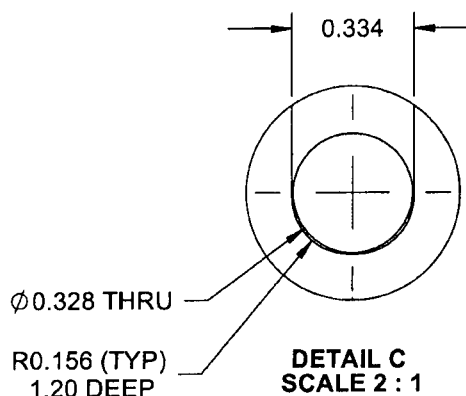
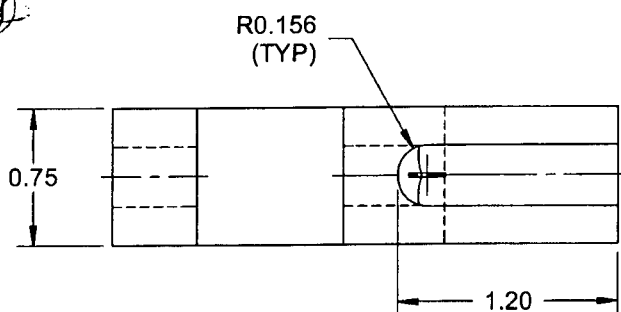
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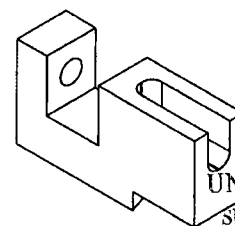
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
06/22/09**D3353-15 LOCK BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW
SCALE 1:2**

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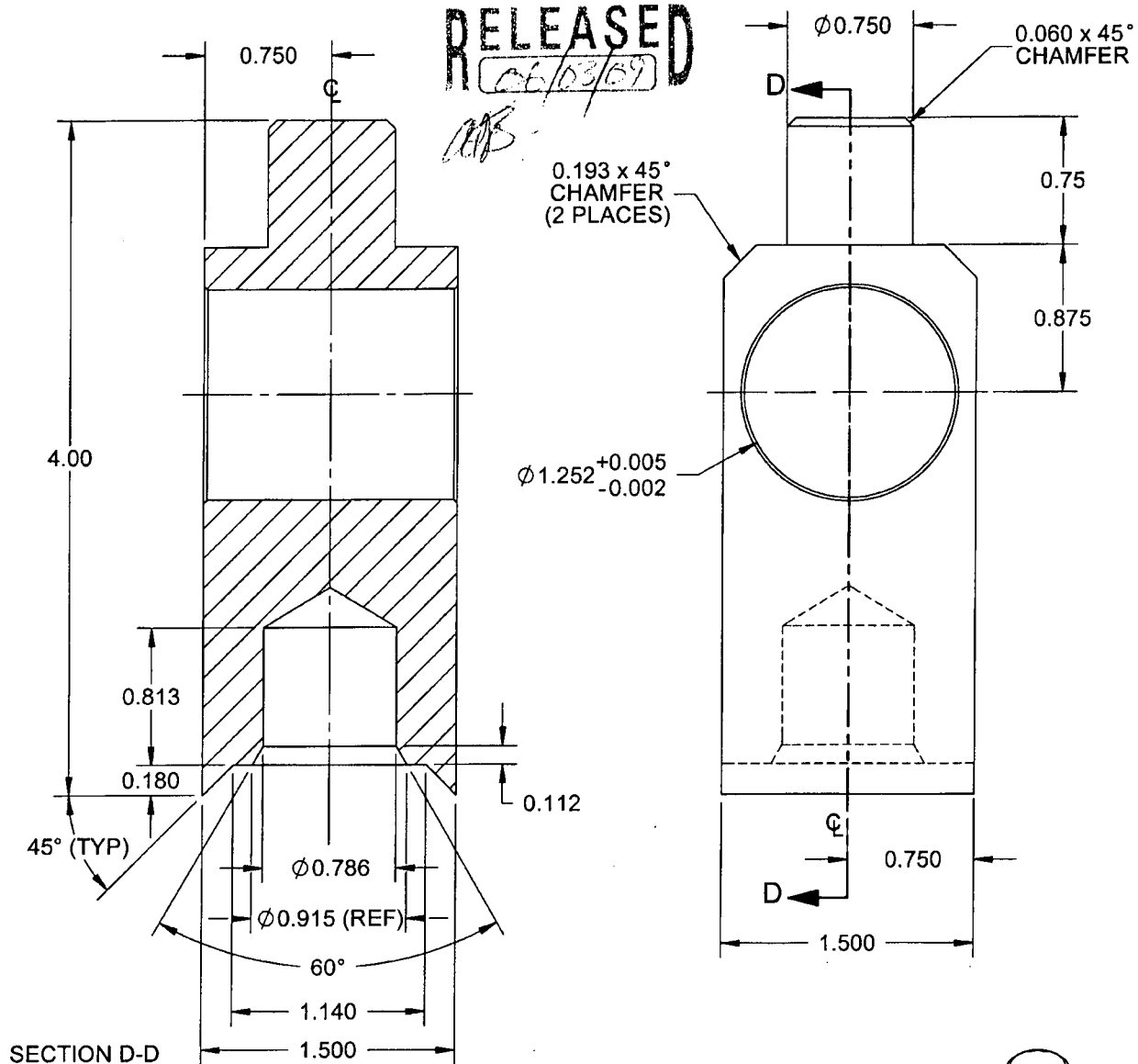
WORK ORDER
NO. 26805

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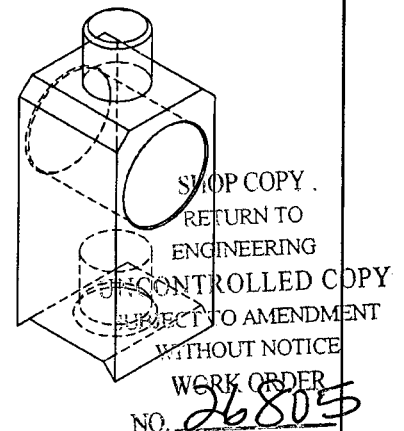
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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DART AEROSPACE LTD		Work Order:	26805
Description: <i>lug Weldment</i>		Part Number:	3353-7
Inspection Dwg: 3353 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	<i>ml ml</i>	Audited by:	<i>2</i>	Prototype Approval:	
Date:	<i>06.05.03</i>	Date:	<i>06.05.03</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	